

Work Order ID 66311

February 9, 2011 3:47:52 PM



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Item ID: D4306-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 2/10/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/17/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-02-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4306

B

100

0.00



Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D4306

SAD 11-02-14

①

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8/11/02/15

⑦

Quality Control

Work Order ID 66311



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Required Date: 2/17/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Packaging Packaging	Identify as per dwg & Stock Location: <u>WT</u> Memo	0.00 0.00		<u>SAD</u> <u>11-02-15</u>		<u>①</u>			
130 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>CH</u>	<u>MF</u>	<u>11-02-16</u> <u>11-02-16</u>	

Picklist Print

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Work Order ID: 66311

Parent Item: D4306-1

Parent Item Name: Rib




Start Date: 2/10/11

Required Date: 2/17/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	304.4944	4.1666	4.385895			
													
304 SQ Tube .75x.75x.049W													

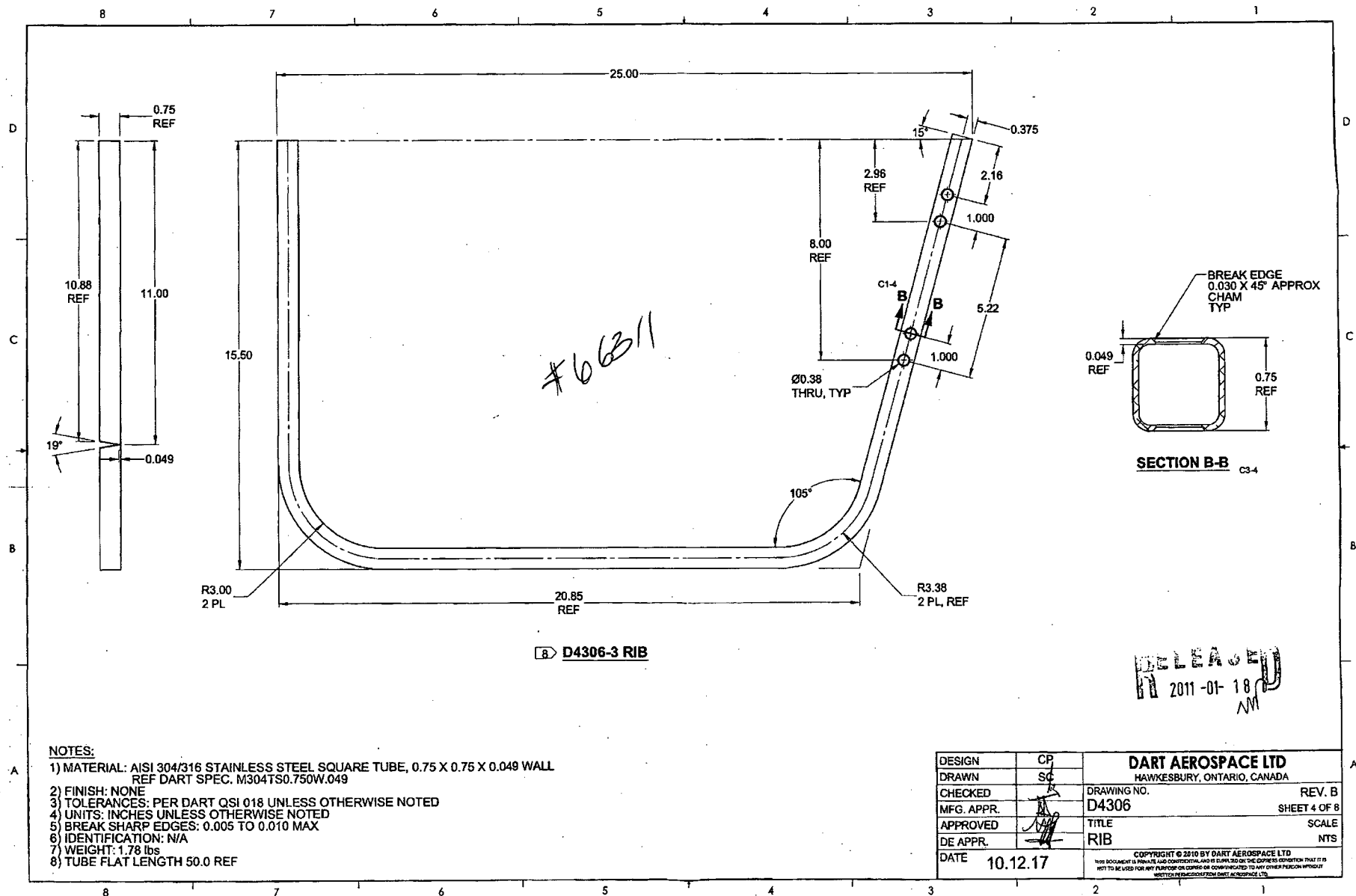


SAD

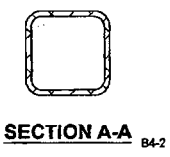
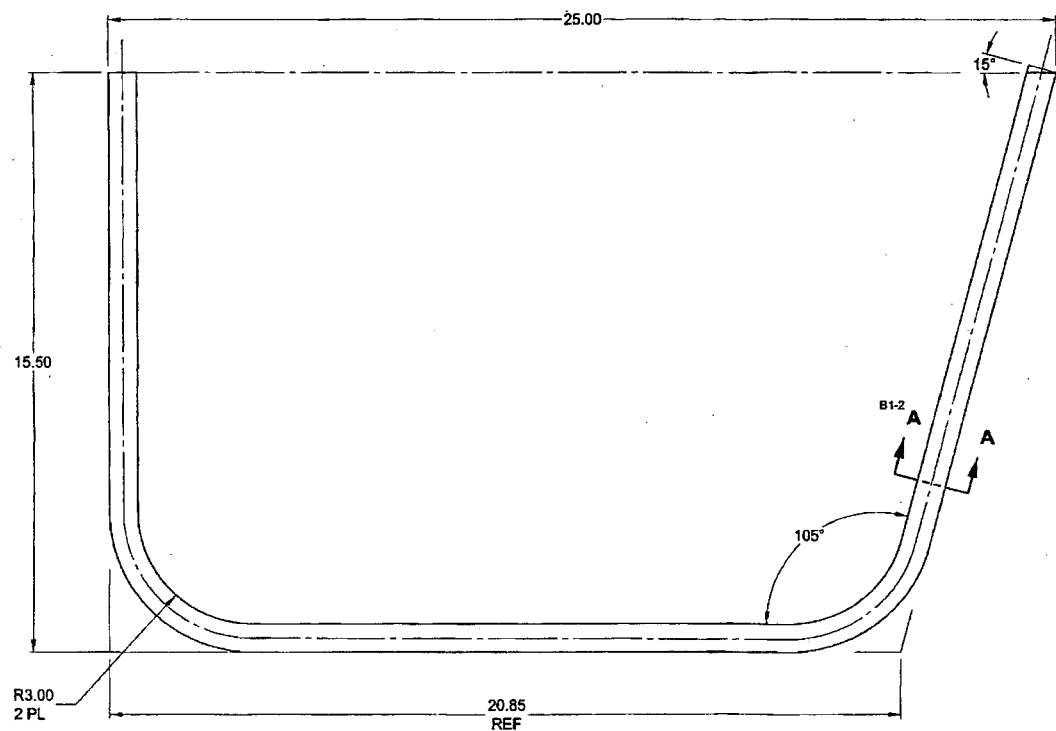
11-02-14

Location	Loc Qty	Loc Code
MAT	267.5485679	
113763	0	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
116319	25.1993	
116509	19.3317	
116719	14.8672	
116788	200	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	36.9458	
114992	11.0693	
115260	25.8765	

4.38589



#66311



RELEASED
R 2011-01-18
M

B D4306-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4306	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		RIB	NTS
DATE	10.12.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries